

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000490**Date Inspected:** 12-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Bing, Hou Jing Yao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans Mock-Up**Summary of Items Observed:**

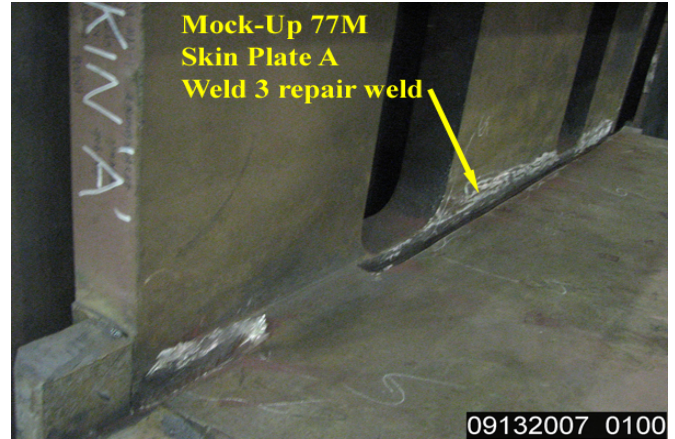
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M and 114M, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Mock-Up 77M, Skin Plate A	NA	NA	Weld Repair

Mock-Up 77M, Skin Plate A: ZPMC completed weld repair excavation, material preparation and the magnetic particle test (MT) examination at stiffener plate mp2 to skin plate MA2, complete joint penetration weld, identified as weld #3. This weld had been previously ultrasonically tested by ZPMC and found to be non-compliant. Caltrans QA Inspector observed the weld excavation area for workmanship and found it to be in compliance with contract requirements. After the completion of the weld inspection, Caltrans QA Inspector observed shop worker installing heating panel at the weld repair location. ZPMC QA inspector, Mr. Fu Yu hong stated that ZPMC would not be welding on this weld repair tonight, but would prepare it for the day shift to start welding on. Following pictures illustrate the repair weld location and the installation of the heating panel.

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified with the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
